

Date: Monday, 4/24/2006 10:24:58 AM
 User: Kim Johnston

Process Sheet

Split 2 for 05-23 need

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26758-1
 Estimate Number : 11044
 P.O. Number : NIA
 This Issue : 4/24/2006 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : NIA Type : MACHINED PARTS
 Previous Run : NIA
 Written By : *See comment below*
 Checked & Approved By : *06.04.24*
 Comment : Est. A 04.11.30 New issue KJ/JLM

Drawing Name : STRUT
 Part Number : D28105
 Drawing Number : D2810 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : NIA
 Due Date : 5/5/2006

Qty: *16* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2.1000 f(s)/Unit Total : 8.4000 f(s)

304 RD Tube .500 x .035W

Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control

Dwg D2727 using Jig DT8012

Batch: *1719480*

FF 06.05.09 16

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr

FF 06.05.09 16
MF 06.05.15 16

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 06/05/23 16

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 05 31 16

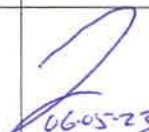
5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION






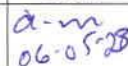



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

0.2 06-05-31 16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-23	4	Split w/o - need 3 struts				W	 06-05-23

Part No: D28105 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA:  Date: 26/06/01
QA: N/C Closed:  Date: 06.06.01

NCR: <u>26758</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-23	4.0	Struts P.C. white. Employee didn't read w/o and assumed they were white.		Strip: Polish struts free of white powder coat, and powder coat black. Ensure employee reads the w/o more carefully: refers to Dwg's.	 06-05-23	 06-05-23		 06-05-23

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:24:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 26758

Part Number: D28105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57162

6415731 (13)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

13
12/06/06

Job Completion



U 26.06.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

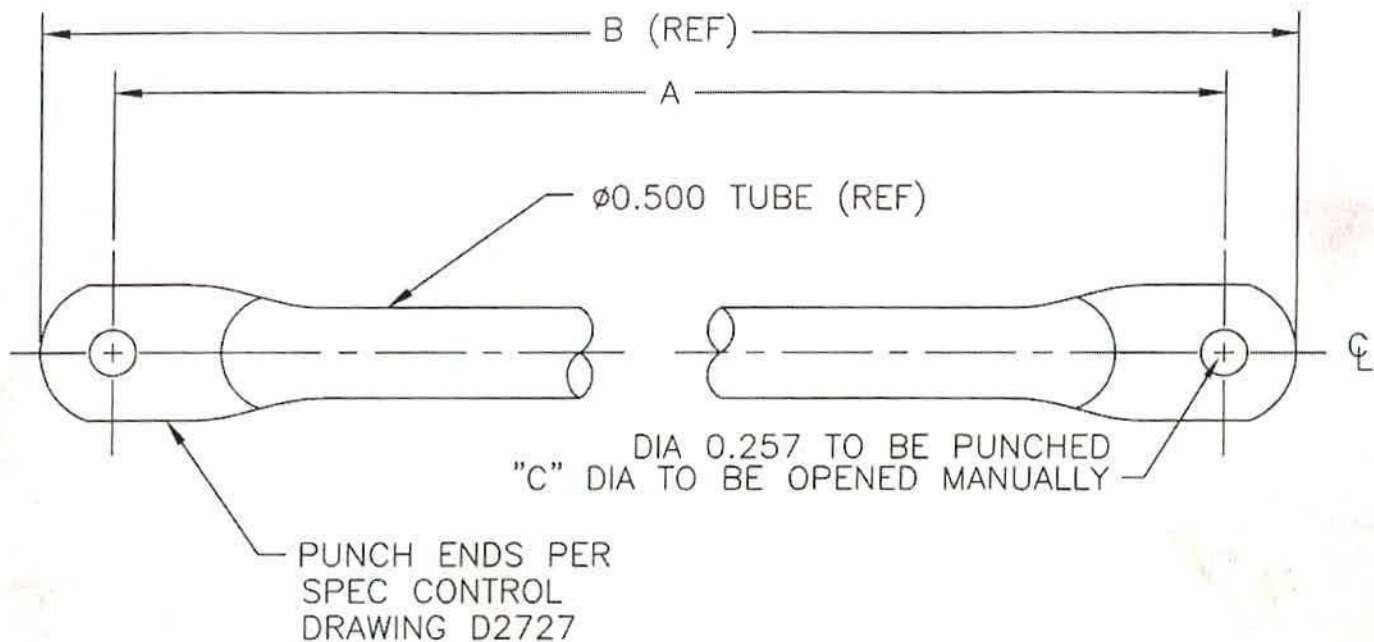
NOTE: Date & initial all entries

DART

RELEASE

05-03-11

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT	SCALE NTS
A	00.11.08	NEW ISSUE	
B	03.09.11	ADD FINISH	
C	04.11.22	ADD -5	



PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
✓ D2810-5	23.01	23.81	0.266

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WORK ORDER
NO. 26758

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.500 \times 0.035$ WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

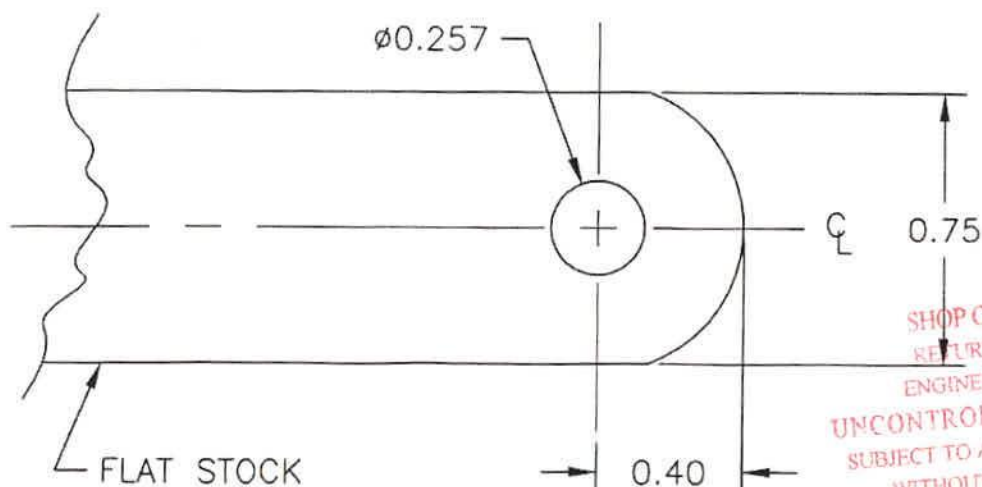
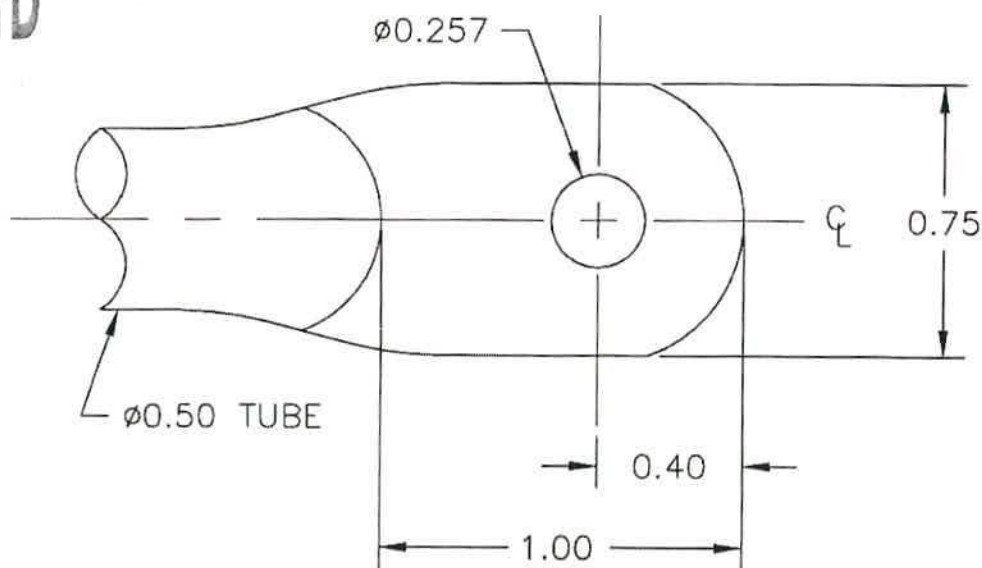
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>my</i>	APPROVED <i>JA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>ACP</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE

NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

A1

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